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(54) Method and apparatus for forming a three piece tailor welded door blank

(57) A three-piece tailor welded blank vehicle door structure (40) includes a periphery (46) defined by a bottom portion (48), a pair of opposing side portions (50,52), a top portion (52), and an inclined portion (66). A first thickness gage sheet material portion (90) is disposed generally along the door hinge side of the door

structure (40). A second thicker gage sheet material portion (94) is disposed generally along the door latch side of the door structure (40). A thinner gage sheet material portion (92) is disposed between the first and second thickness gage sheet material portions (90,94), whereby the overall weight of the vehicle door is reduced.

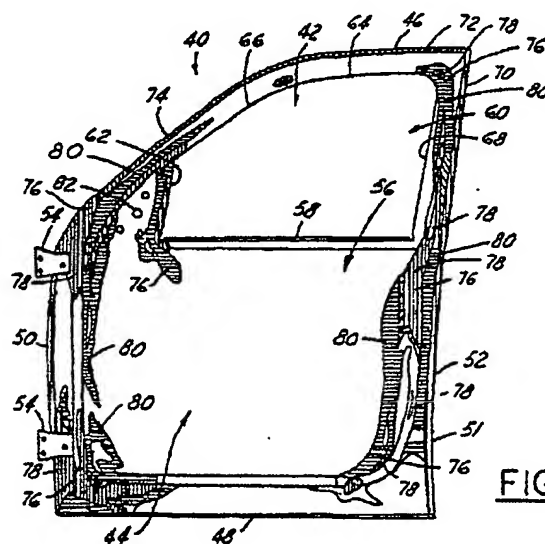


FIG.2

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# EUROPEAN SEARCH REPORT

Application Number  
EP 01 30 3671

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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
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X	EP 0 803 389 A (BAYERISCHE MOTOREN WERKE AG ; YMOS AG IND PRODUKTE (DE)) 29 October 1997 (1997-10-29) * column 1, line 58 - column 3, line 36; figures 1,2 *	1,3-10	
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A	WO 00 00320 A (AUTOMATED WELDING SYSTEMS INC ; XIAO MIN (CA)) 6 January 2000 (2000-01-06) * page 1, paragraph 2 * * page 41, paragraph 2 - paragraph 4; figures 1,54 *	1	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
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Place of search		Date of completion of the search	Examiner
MUNICH		3 June 2003	Schmid, K
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons &amp; : member of the same patent family, corresponding document</p>			

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